

Date: Monday, 2/19/2007 8:07:38 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING BRACKET
Job Number : 30748	
Estimate Number : 12473	
P.O. Number : <u>NIA</u>	Part Number : D3246041
This Issue : 2/19/2007 S.O. No. : <u>NIA</u>	Drawing Number : D3246 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NIA</u> Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 28470	Material : <u>NIA</u>
Written By : <u>[Signature]</u>	Due Date : 2/26/2007
Checked & Approved By : <u>[Signature] 07.02.19</u>	Qty: <u>4</u> / Um: Each
Comment : Est Rev A New Issue 06-06-22 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.3252 sf(s)/Unit Total : 0.6504 sf(s)

2024-T3 .050 sheet

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050)

Identify for D3246-1 Batch: M103321

SAD 07/02/19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg Dsi9279

Dwg Rev: A2Prog Rev: A7

2-Deburr if necessary

SAD 07/02/19

4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/19

4

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 07/02/19

5.0	BRAKE NC	NO BRAKE
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Comment: NC BRAKE

Deburr

Form as per Dwg D3246

C'sink as per Dwg D3246

SAD 07/02/20  
 FF 07/02/20

④  
 ④

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:38 AM  
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Drawing Name: MOUNTING BRACKET

Job Number: 30748

Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*For 2.24 @*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FL/HL*

*07/02/22 (4)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*For 2.22*

9.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : ~~16.0000~~ Each(s) *32x*

Rivet

Pick:

Qty Part Number Description Batch

8 MS20426AD3-3 Rivet *M 7681*

✓

10.0

MS21059L3

Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~8.0000~~ Each(s) *16x*

Nut Plate

Pick:

Qty Part Number Description Batch

4 MS21059L3 Nut Plate ~~M 19393~~ *M 19393*

✓

Identify as D3246-041

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates as per Dwg D3246

*M 02/07/23 x4*

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*For 2.26 @*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 2 Date: 07/02/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:38 AM  
User: Kim Johnston

# Process Sheet

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Drawing Name: MOUNTING BRACKET

Job Number: 30748

Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

5

By 1/4/26 (4)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

12/16/27

Job Completion



12/16/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

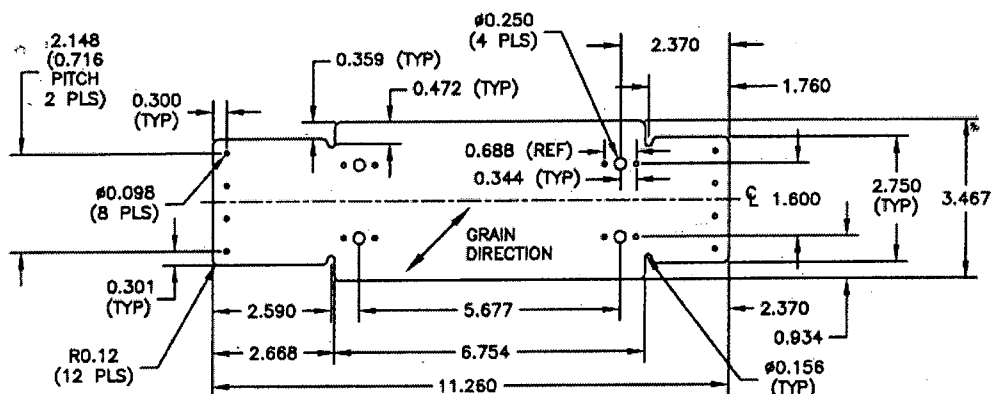
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

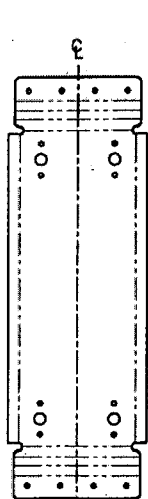


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
A1	04.06.16	CHANGE RIVET; ADDED C'SINK	

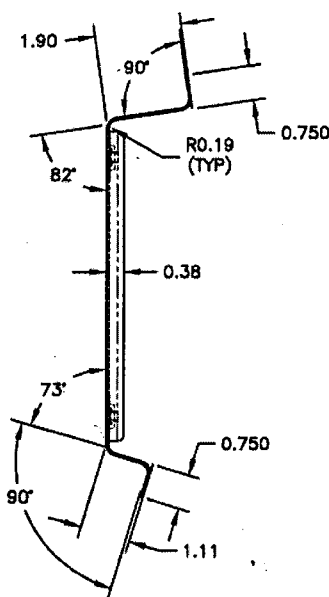
RELEASED  
04.05.07 [Signature]



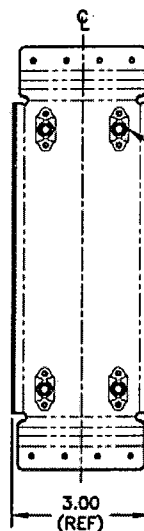
D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY



MS21059-L3  
NUT PLATE (1)  
MS20470AD3-4 RIVET (2)  
(4 PLACES)  
INSTALL AFTER  
ALODINE  
C'SINK  $\phi 0.185 \times 100^\circ$   
MS20426AD3-3 RIVET (2)



NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30748

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30748
<b>Description:</b>		<b>Part Number:</b> D3246-041
<b>Inspection Dwg:</b>	<b>Rev:</b>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.250	+0.005/-0.001	Ø 0.251	✓		Vern	
Ø 0.098	+0.004/-0.001	Ø 0.101	✓		Vern	
11.260	+/- 0.010	11.270	✓		Vern	
6.754	+/- 0.010	6.751	✓		Vern	
2.668	+/- 0.010	2.670	✓		Vern	
5.677	+/- 0.010	5.685	✓		Vern	
3.467	+/- 0.010	3.474	✓		Vern	
2.750	+/- 0.010	2.759	✓		Vern	
0.934	+/- 0.010	0.935	✓		Vern	
1.600	+/- 0.010	1.597	✓		Vern	
2.370	+/- 0.010	2.370	✓		Vern	
0.300	+/- 0.010	0.307	✓		Vern	
2.148	+/- 0.010	2.140	✓		Vern	
0.716	+/- 0.010	0.713	✓		Vern	
0.301	+/- 0.010	0.308	✓		Vern	
6.688	+/- 0.010	6.686	✓		Vern	
0.344	+/- 0.010	0.342	✓		Vern	
0.050	+/- 0.010	0.048	✓		Vern	

<b>Measured by:</b>	JAD
<b>Date:</b>	07/02/19

<b>Audited by:</b>	[Signature]
<b>Date:</b>	07/02/19

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



